

Work Order ID 124017

124017

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-09-05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	28P							
D2750-042	G								
D3492	C								

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

record fwd angle: 89.2° DGL

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

Mh

1 2 14-10-29

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September-05-14 1:42:14 PM

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Item ID: D350-636-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110	Skidtubes								
Skidtubes	<p>Memo</p> <p>1- Pick D2600-3 Bent</p> <p>2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750</p> <p>3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.</p> <p>***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE***</p> <p>Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)</p> <p>4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.</p> <p>5- Drill only two fwd step holes using DT9616. Ensure proper positioning.</p> <p>6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".</p> <p>7- Open up holes of Detail J to 0.297" (total of 2 holes per side)</p> <p>8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004</p>	0.00							

DL 14-9-9

0214-09-10

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M122399

9- Grind welds flush as per Dwg D2750

78E14-09-10

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo 0.00

Quality Control

CPC 14-9-11

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo 0.00

Quality Control

DAS
03
8-88

DP 14-9-11

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/05/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

DAS 03

14-9-19

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Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop

NS2

Start Date: 9/05/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/05/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 129457
exp. date: 14-11-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: M129399

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11- Spot face ground handling holes section (total of 4 places per side) as per

DP 14-9-19

DGC 14-9-19

BE 14-09-22

14-9-23 JK

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 9/05/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									DAS 9 9-89
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								DAS 9 9-89

14-9-24

① 14.09.25

① 14.09.25

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Item ID: D350-636-012

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>12B975</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>130531</u>								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

1844 d 111 10/05

1 ————— CN 14/10/16

14-10-16

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Item ID: D350-636-012

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N900040100

Setup Start ***NS1***

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Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11130277</u>								
	EXP DATE: <u>15108</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11129305</u> RTU 34813611 1125792 exp: 15/06								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>11122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89 14-10-22

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Work Order ID: 124017

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I02.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	1.0000	1	1			
D2600-3-BENT									**			DGC 11-9-9	
Extrusion Bent													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					LG002 123533	1							
					119680	1							
D2744		Manufactured	No			110	Each	53.0000	1	1			
D2744									**			BENT-09-10	
Cap													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					LG001 113128	53							
					115440	52							
						1							

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Work Order ID: 124017

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

3

117245

2

117803

1

① 14-9-19 JLL

D2743

Manufactured No

160

Each

192.0000

8

8

D2743

Crossbolt Spacer

BE14-09-22

Location

Loc Qty

Loc Code

LG001

192

109799

1

112729

59

119609

58

120481

74

②

D3490-3

Manufactured No

160

Each

72.0000

4

4

D3490-3

Cross Bolt Spacer

BE14-09-22

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

4

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Work Order ID: 124017

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

100.0000

4

4

D3490-1

Cross Bolt Spacer

DE 14-09-22

Location

Loc Qty

Loc Code

LG

85

122457

85

LG001

15

112737

1

116358

14

D3631-1

Manufactured No

230

Each

126.0000

8

8

D3631-1

Washer

ll 14/10/16

Location

Loc Qty

Loc Code

FP001

126

110258

16

119553

10

123452

100

x 8

D3791-1

Manufactured No

230

Each

6.0000

1

1

D3791-1

Wearpad

ll 14/10/17

Location

Loc Qty

Loc Code

FP001

1

92689

1

FP002

5

118942

5

x 1

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Work Order ID: 124017

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

8.0000

1

1

D3793-3

Wearplate Aft

**

lll 14/10/17

Location

Loc Qty

Loc Code

FP001

1

13123333

104212

1

FP002

7

120141

7

MS21043-6

Purchased No

230

Each

58.0000

4

4

MS21043-6

NUT

**

lll 14/10/17

Location

Loc Qty

Loc Code

FG

20

M130325

103693

20

ST306

38

m127255

6

m127813

32

D3794-1

Manufactured No

230

Each

2.0000

1

1

D3794-1

Gasket Fwd

**

lll 14/10/17

Location

Loc Qty

Loc Code

FP001

2

13123497

109207

1

93381

1

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

383.0000

8

8

NAS1611-010

O-RING

**

ell 11/10/13

Location

Loc Qty

Loc Code

FP001

383

m126988

3

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

XG

D2741

Manufactured No

250

Each

48.0000

1

1

D2741

Blade

**

DAS
26
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

/X

NAS1515H3L

Purchased No

230

Each

293.0000

4

4

***NAS1515H3I ***

Washer

**

ell 11/10/13

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

XJ

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Shop Packet Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

140.0000

8

8

NAS1611-013

O-RING

**

ll 11/10/17

Location

Loc Qty

Loc Code

FP001

140

14130358

x2

m128375

72

m129430

68

x6

AN3C6A

Purchased

No

230

Each

1,058.000

4

4

AN3C6A

Bolt

**

ll 11/10/17

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

1048

m125709

52

m128769

996

x1

NAS1149C0832R

Purchased

No

230

Each

258.0000

1

1

NAS1149C0832R

Washer

**

ll 11/10/17

Location

Loc Qty

Loc Code

ST277

258

m114915

108

m125807

150

x1

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

D3536-25

Gasket Center

ll 4/10/17

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

9

110652

1

123300

7

93696

1

B124099

xl

D3794-3

Manufactured No

230

Each

11.0000

1

1

D3794-3

Gasket Aft

ll 4/10/17

Location

Loc Qty

Loc Code

FP001

11

111457

8

122529

2

92658

1

B124942

xl

AN3C5A

Purchased No

230

Each

140.0000

34

34

AN3C5A

Bolt

ll 4/10/17

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

135

M128911

27

M128973

10

M129913

98

M1130358

X3J

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

93.0000

3

3

D3537-1

Wearpad

OCT 29 2014

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

75

113839

4

120644

52

120645

18

93945

1

D3535-25

Manufactured No

230

Each

24.0000

1

1

D3535-25

Wearplate Center

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

22

110744

1

123415

20

93278

1

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

142.0000

8

8

D3492-3

Plug

lll 14/10/17

Location

Loc Qty

Loc Code

FP001

142

104853

24

107331

1

112739

1

115807

6

118977

10

123464

100

B124027

x 8

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

NAS1149C0332R

WASHER

lll 14/10/17

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

x 38

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

16.0000

1

1

D3488-042

Blade Fitting RH

ll 10/10/17

Location

Loc Qty

Loc Code

FP001

15

115599

7

120135

7

98887

1

FP002

1

112237

1

ALS4-1032-225

AEIS8-1032-225 Purchased No

230

Each

258.0000

38

38

AI S4-1032-225

✓ ALS 7 - 1032-225

ll 10/10/17

Rivnut

Location

Loc Qty

Loc Code

FG

30

M127028

30

11130565

x38

ST267

228

M127028

10

M127092

26

M128179

192

D3492-1

Manufactured No

230

Each

121.0000

8

8

D3492-1

Plug

ll 10/10/17

Location

Loc Qty

Loc Code

FP001

121

111578

2

114879

7

119646

2

120519

50

122460

60

x8

Picklist Print

September-05-14 1:42:18 PM

Page 11

Work Order ID: 124017

124017

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

11.0000

1

1

D3793-1

Wearplate Fwd

**

ell 11/10/17

Location

Loc Qty

Loc Code

FP002

11

112741

2

120212

8

92382

1

X1

AN8C35A

Purchased

No

230

Each

73.0000

1

1

AN8C35A

Bolt

**

ell 11/10/17

Location

Loc Qty

Loc Code

FG

4

121275

4

M128798

st

FP001

69

m126293

29

m127823

1

m130114

39

X1

MS21083C8

Purchased

No

230

Each

64.0000

1

1

MS21083C8

Nut

**

ell 11/10/17

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

X1

Picklist Print

September-05-14 1:42:18 PM

Page 12

Work Order ID: 124017

124017

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

145.0000

8

8

D2745

Bushing

**

ll 14/10/17

Location

Loc Qty

Loc Code

ST010

145

107336

4

113176

2

117099

7

119572

51

122643

73

90323

2

93336

6

x8

AN6C44A

Purchased No

230

Each

45.0000

4

4

AN6C44A

Bolt

**

ll 14/10/17

Location

Loc Qty

Loc Code

FG

2

103964

2

ST333

43

m128319

2

m128700

1

m129199

40

x4

D3532-1

Manufactured No

250

Each

34.0000

2

2

D3532-1

Spacer

**

DAS
28
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

ST048

34

115855

3

117198

3

122723

21

123513

7

2x

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Page 12

Picklist Print

September-05-14 1:42:18 PM

Page 13

Work Order ID: 124017

124017

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

64.0000

2

MS21083C8

Nut

**

2

m130358

DAS
26
9-89

S

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

NAS1149D0863J

Purchased

No

250

Each

795.0000

2

NAS1149D0863.J

Washer

**

2

DAS
26
9-89

S

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

ST2776

200

125635

200

D3493-1

Manufactured

No

250

Each

139.0000

2

D3493-1

Washer

**

2

DAS
26
9-89

OCT 29 2014

S

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

September-05-14 1:42:18 PM

Page 14

Work Order ID: 124017

124017

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

62.0000

2

2

AN8C21A

Bolt

DAS
26
9-89

OCT 29 2014



Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

2x

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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14-09-05

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G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PARTS-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 0413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

TITLE

350 SKIDTUBE ASSEMBLY

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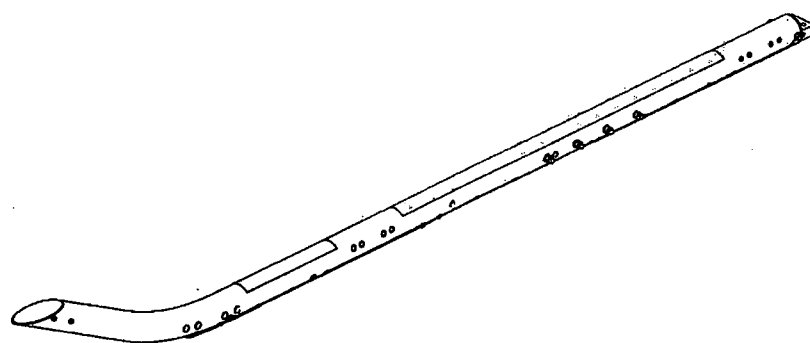
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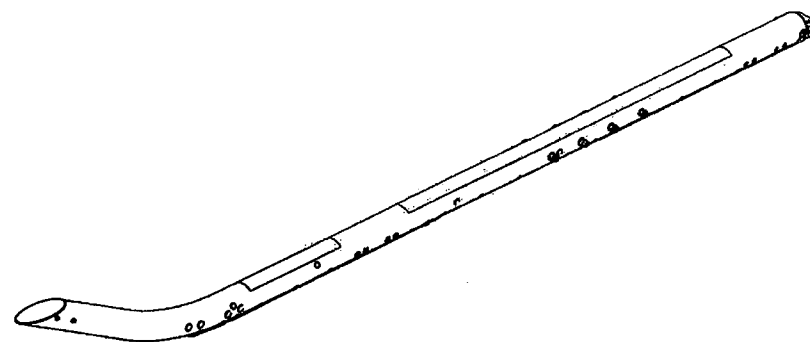
SHEET 1 OF 11

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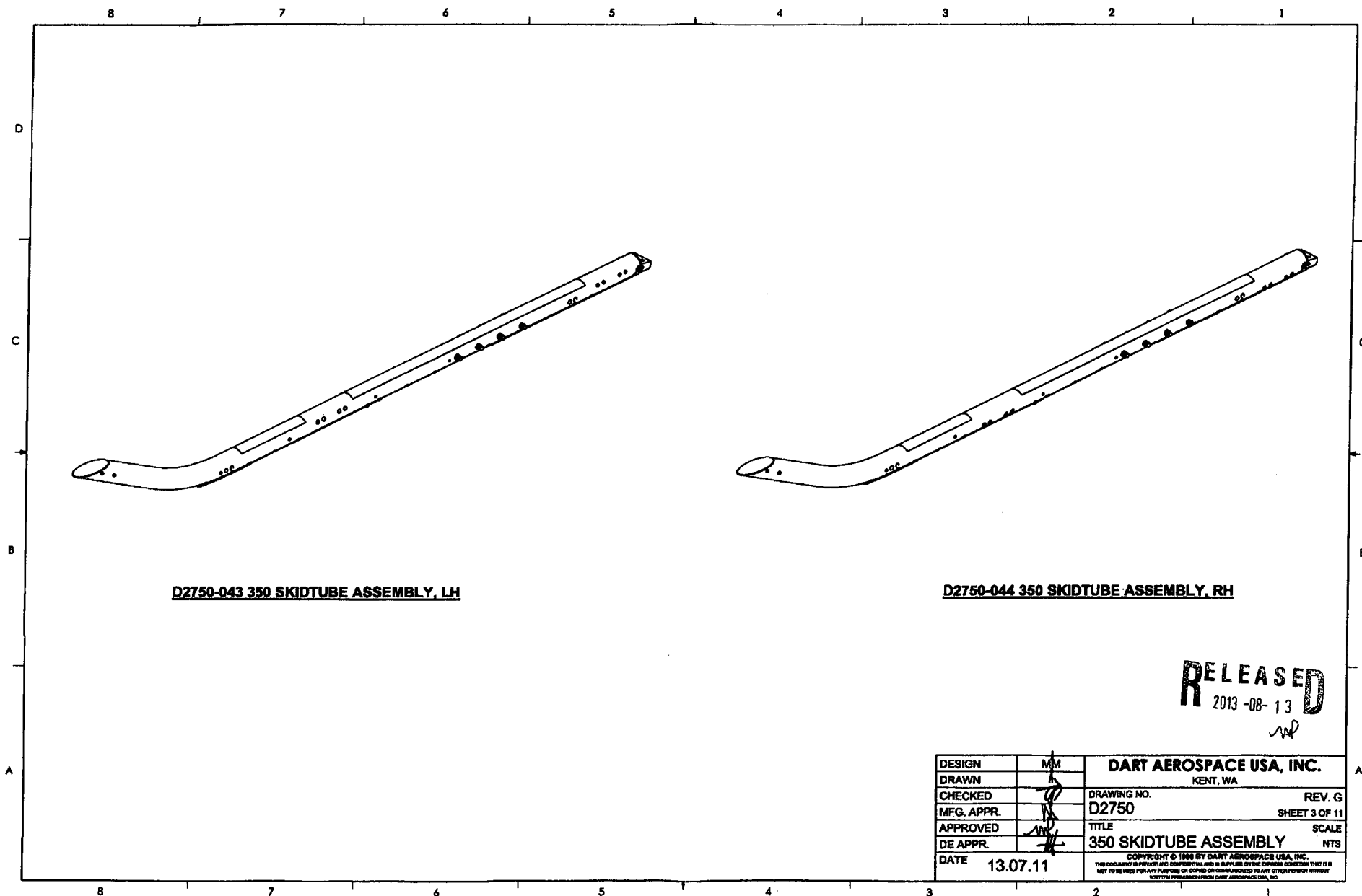
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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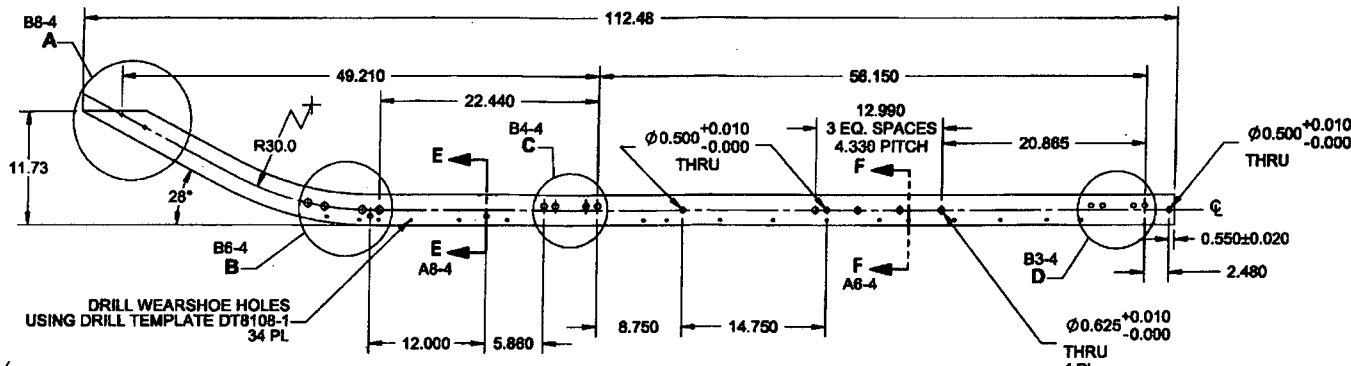
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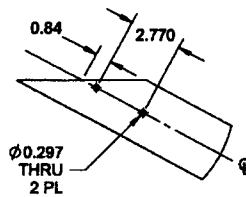
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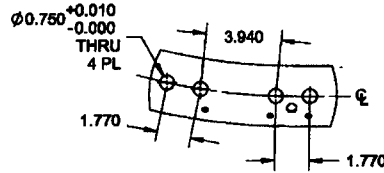
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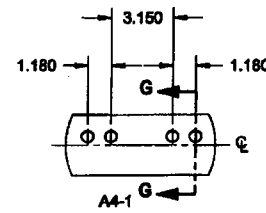
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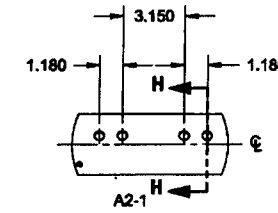
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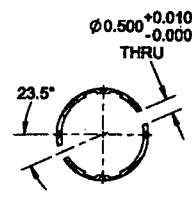
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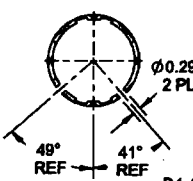
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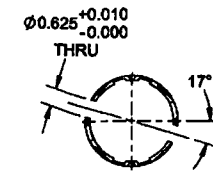
DETAIL D
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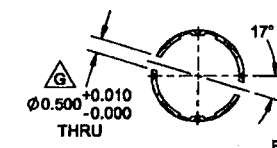
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

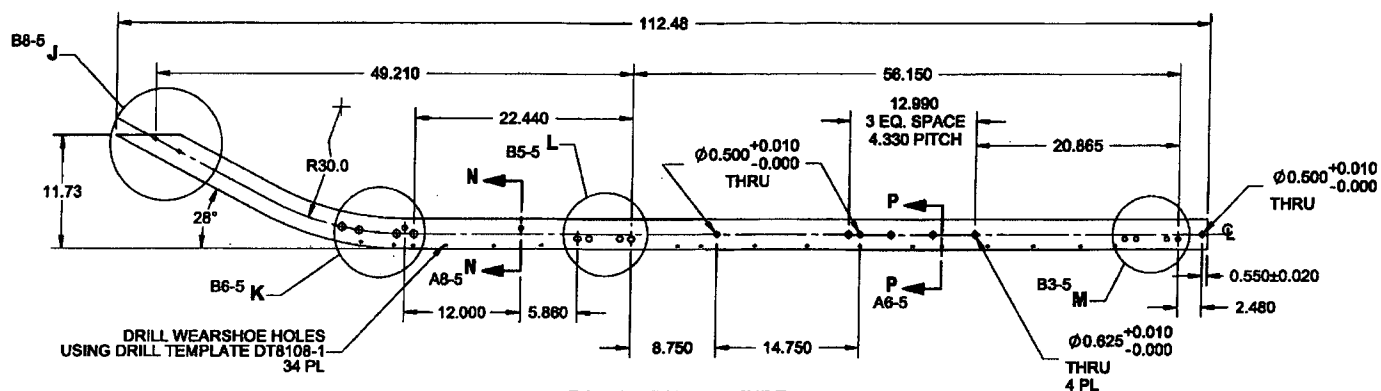


SECTION H-H
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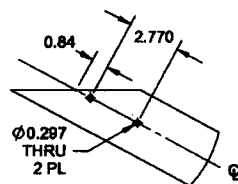
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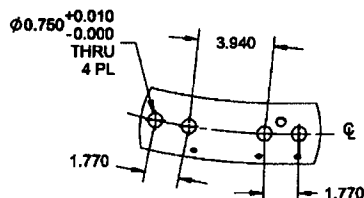
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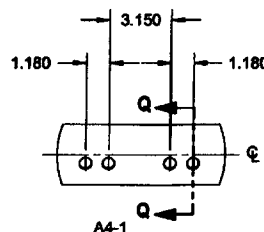
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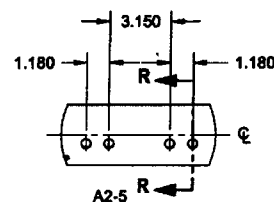
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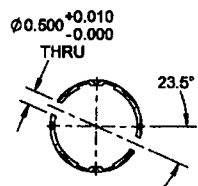
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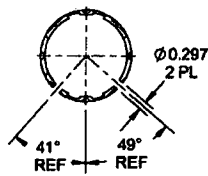
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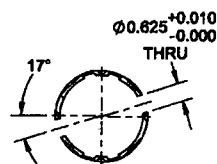
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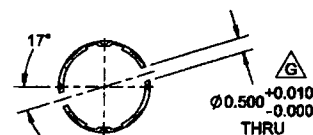
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

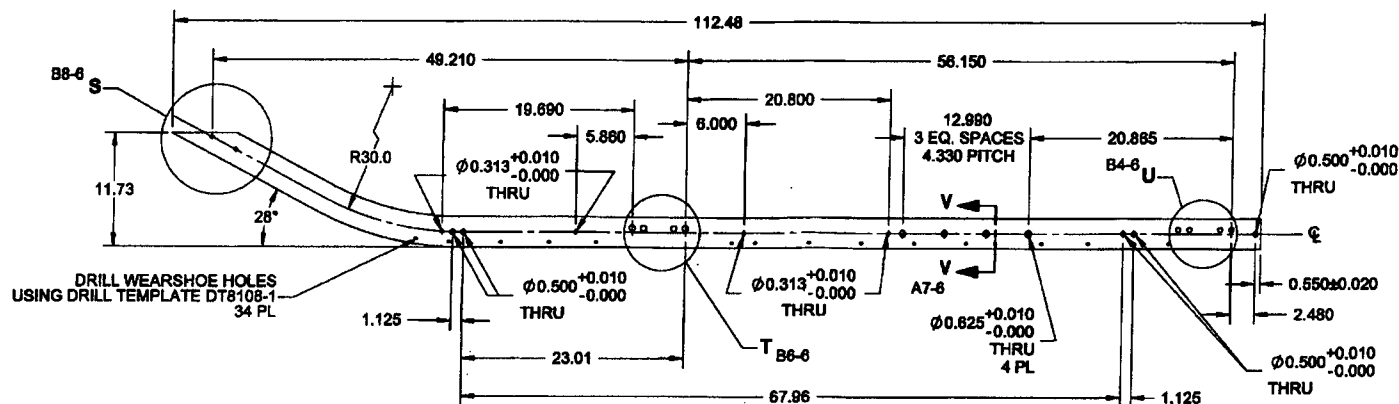


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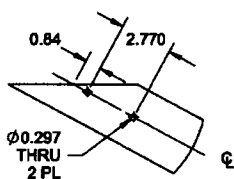
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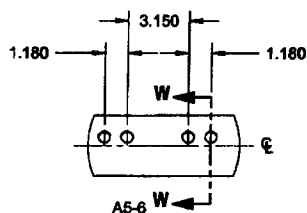
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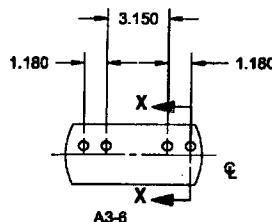
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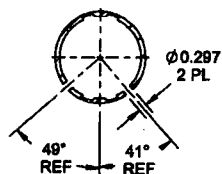
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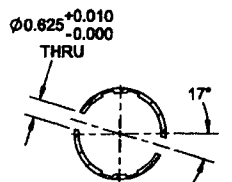
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C5-6
SCALE 2X



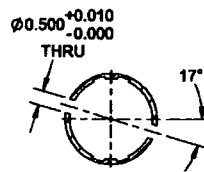
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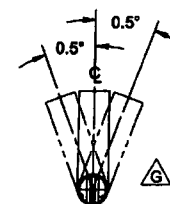
SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL







SECTION X-X
B4-6
SCALE 3X, 4 PL

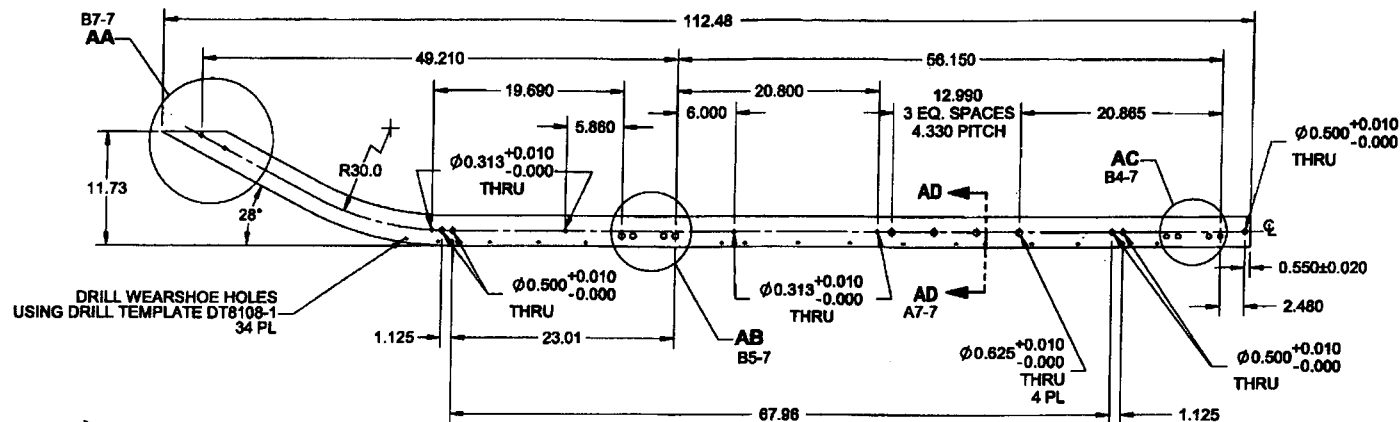


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

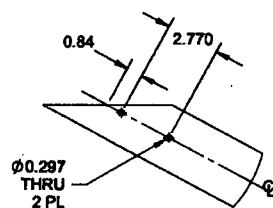
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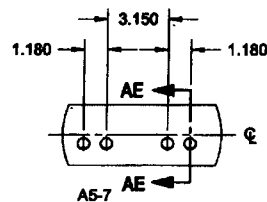
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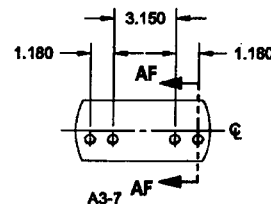
D2750-4 RH SKIDTUBE



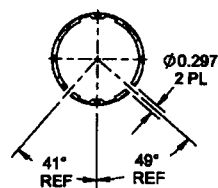
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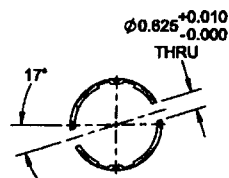
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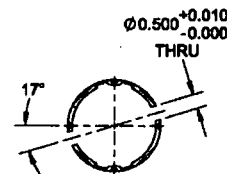
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

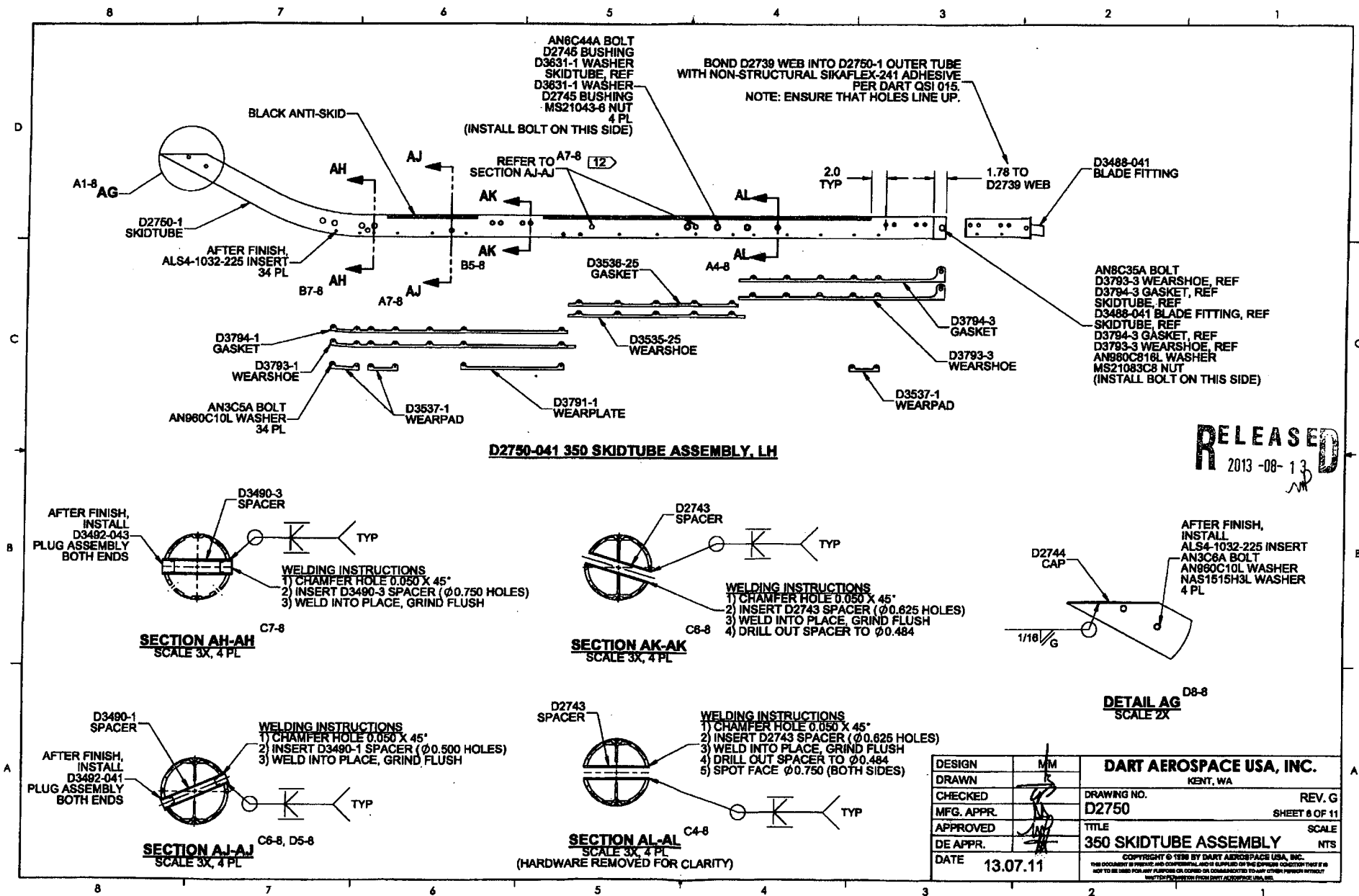


SECTION AF-AF
SCALE 3X, 4 PL

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2013-08-13
MP

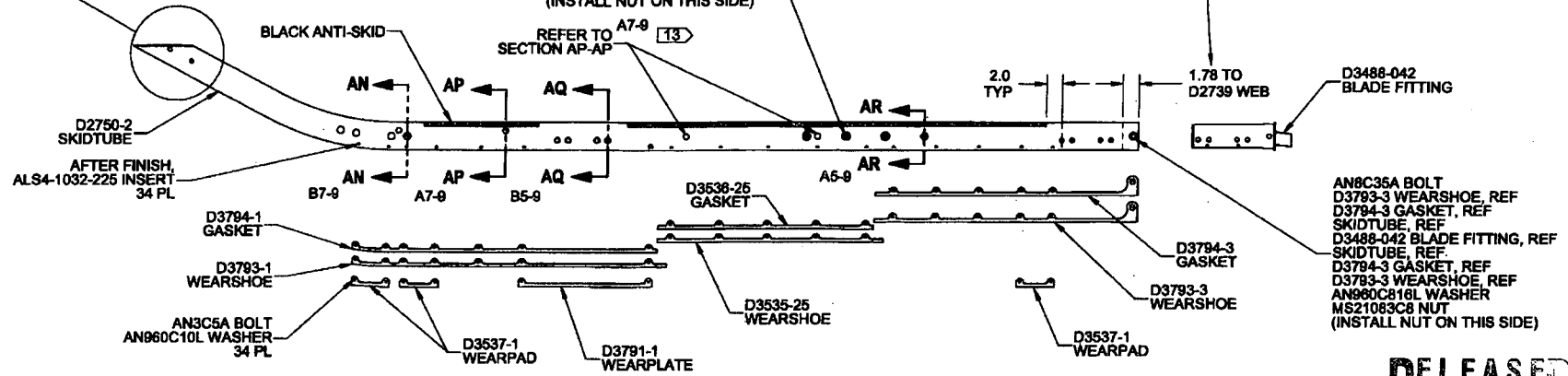
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DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 7 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	13.07.11	SCALE NTS

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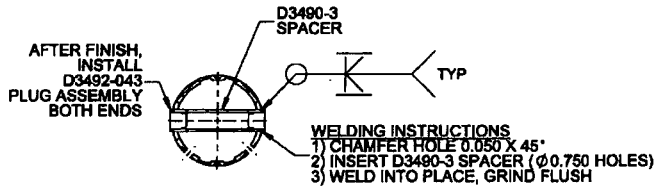
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A1-9
AM

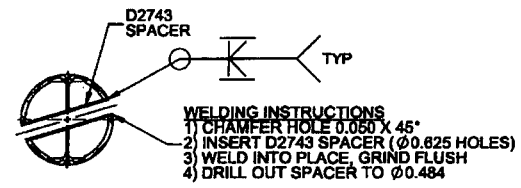


D2750-042 350 SKIDTUBE ASSEMBLY, RH

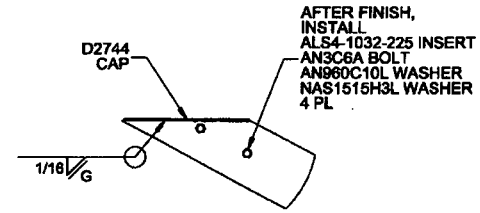
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2013-08-13



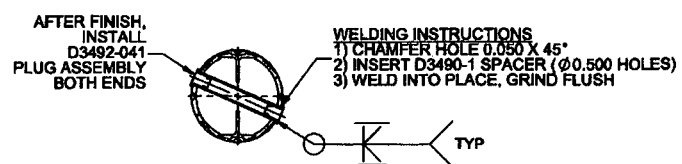
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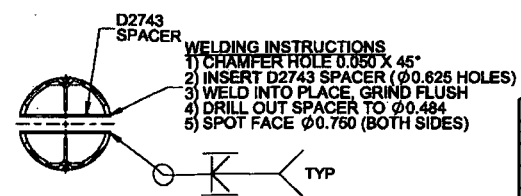
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DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	NM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

